

**Work Order ID 60897**

Monday, July 26, 2010 1:56:34 PM



Page 1

Item ID: D4151-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Fwd Hardpoint Assembly, Lower

Start Date: 7/26/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 8/2/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MDate: 10/7/26

Tooling:

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4151

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg  
Trim rivets to 1.250" long

*EB 10/09/29* (Signature)

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

*SB 10/09/30*

120

0.00



Packaging

Identify as per dwg & Stock Location: 132

Memo

0.00

Packaging

*EB 10/15/30* (4) (Signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/01 AJ

MF

10-9-30

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Monday, July 26, 2010 1:56:37 PM

[illegible][illegible]

**Required Date: 8/2/2010**

**Required Qty: 4.00**

**Comments:** IPP Rev:A 10.06.24 new issue DD verf:EC  
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4151-1 		Manufactured	No			100	Each	0.0000	2	8		8/10/09/29	
Lower Hardpoint Plate													
D4151-5 		Manufactured	No			100	Each	0.0000	1	4		8/10/09/29	
Fwd Basket Instl Stud													
AN3C13A 		Purchased	No			100	Each	0.0000	2	8		8/10/09/29	
Bolt													
MS21043-3 		Purchased	No			100	Each	2,985.000	2	8		8/10/09/29	
Nut													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		76							
				103691		76							
				ST301		2909							
				107280		4							
				112314		2905				8			
NAS1149C0332R 		Purchased	No			100	Each	3,480.000	4	16		8/10/09/29	
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST297		3480							
				113524		10							
				113737		150							
				115000		3320				16			

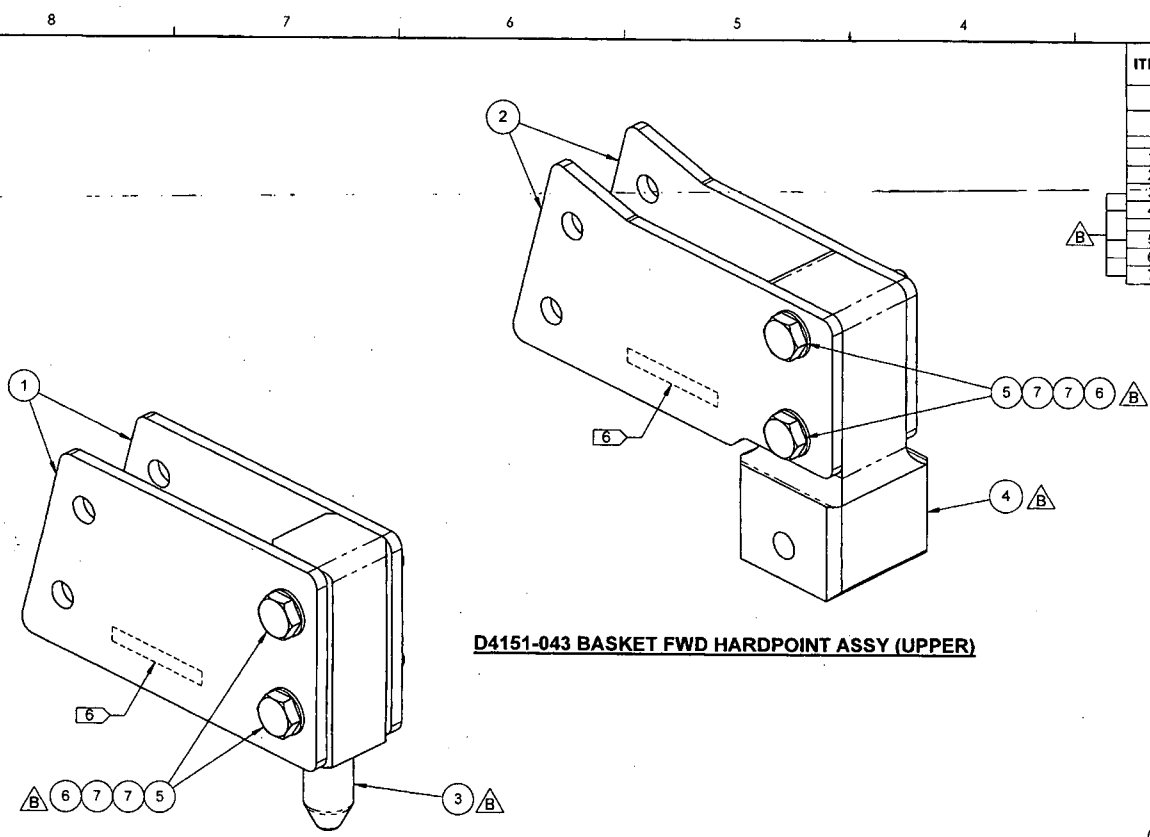
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)**

**D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)**

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN3C13A	BOLT
6	2	2	MS21043-3	NUT
7	4	4	NAS1149C0332R	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 60897

*Pro-7-24*

**RELEASED**  
2010-07-16

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT:
    - D4151-041 = 0.84 lbs
    - D4151-043 = 1.17 lbs

B	ADDED D4151-5/-7 (SHT 3); D4151-5 WAS D3811-1 (ZN B6-1 & D3-1); D4151-7 WAS D3811-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20615-4M20 (ZN C3-1, D3-1 & B6-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2); REASON: SEE TR-D350-607-2 REV. B.		MB	10.07.05
A	NEW ISSUE		MB	10.06.22
REV.	DESCRIPTION	BY	DATE	
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.07.05			

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4151</b>	REV. B SHEET 1 OF 3
TITLE <b>BASKET FWD HARDPOINT</b>	SCALE NTS
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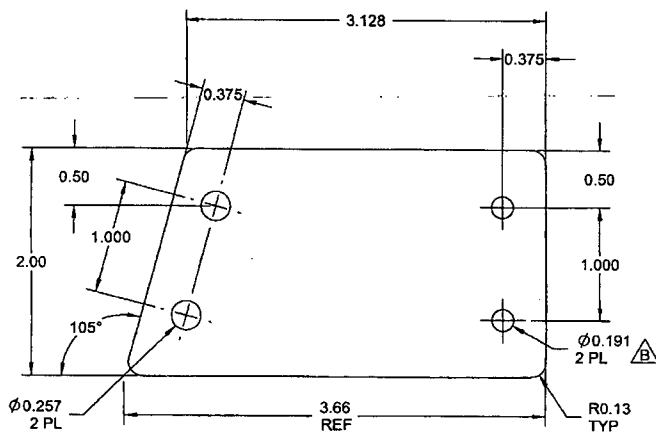
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

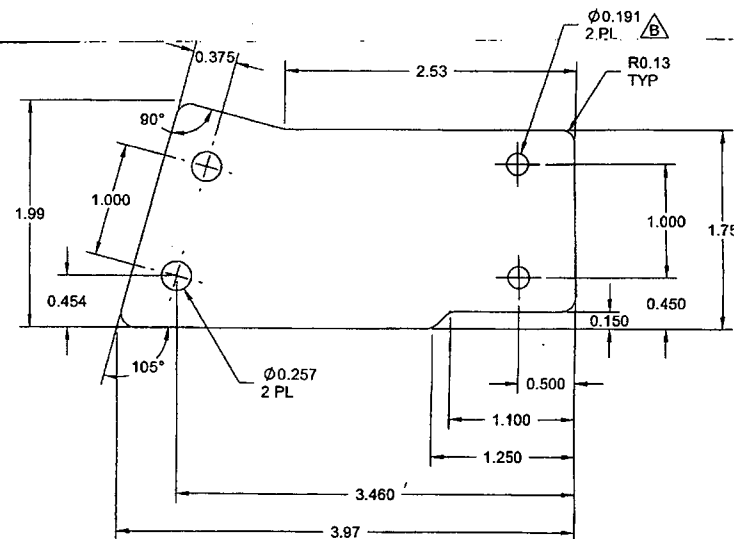
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**NOTE:** Date & initial all entries





0.125 REF  
**D4151-1 LOWER HARDPOINT PLATE**



0.125 REF  
**D4151-3 UPPER HARDPOINT PLATE**

**RELEASED**  
2010-07-16

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT:  
- D4151-1 = 0.24 lbs  
- D4151-3 = 0.23 lbs

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. <b>D4151</b>
MFG. APPR.		REV. B
APPROVED		SHEET 2 OF 3
DE APPR.		TITLE <b>BASKET FWD HARDPOINT</b>
DATE	10:07.05	SCALE NTS
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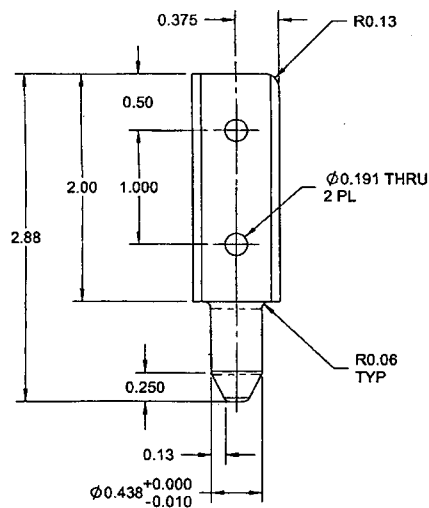
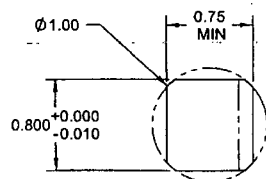
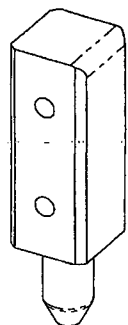
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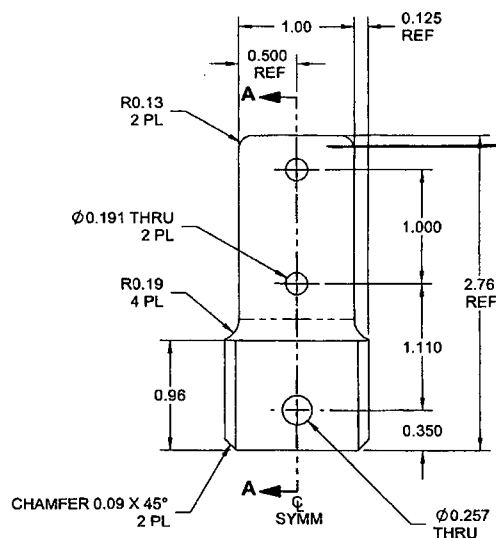
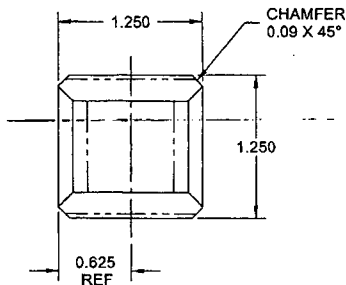
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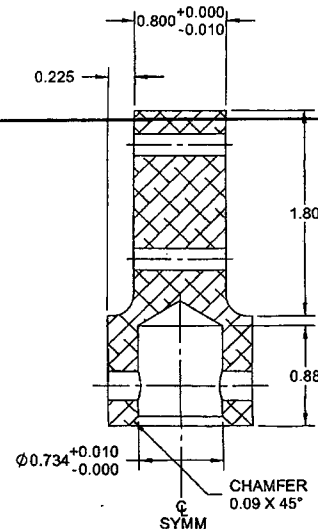
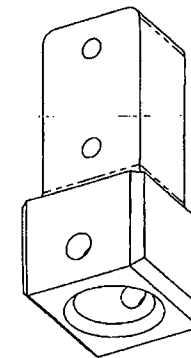
**NOTE:** Date & initial all entries



**D4151-5 FWD BASKET INSTL STUD (LOWER)**



**D4151-7 FWD EYEBOLT RECEIVER (UPPER)**



**SECTION A-A**

**RELEASED**  
2010-07-16

**NOTES:**

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582  
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs  
-7: 0.70 lbs

*w/b 40897*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4151</b>	REV. B
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE <b>BASKET FWD HARDPOINT</b>	SCALE
DE APPR.			NTS
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